

Ship 20/08

Dart Aerospace Ltd.

Date: Wednesday, 06/08/2008 2:06:28 PM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT PLATE RH
Job Number	: 41025		
Estimate Number	: 13284		
P.O. Number	:	Part Number	: D36974
This Issue	: 06/08/2008 S.O. No. :	Drawing Number	: D3697 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 40663	Material	:
Written By	:	Due Date	: 28/08/2008
Checked & Approved By	: <u>Julie Lecocq</u> 08-8-06	Qty:	5 Um: Each
Comment	: Est Rev:A 08-04-25 new issue DD verified by:EC Est Rev:B 08-07-14 revB as per dwg DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.4797 sf(s)/Unit Total : 0.9595 sf(s)  
6061T6 aluminium sheet .050" thick  
(M6061T6S050)  
Batch: 104186 HB 8-8-7

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3697  
Dwg Rev: 8 HB 8-8-7  
Prog Rev: 15  
\*\*\*grain direction along 3.44" \*\*\*  
2- Deburr if necessary HB 8-8-7



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/08/12 (x8)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
Bend as per Dwg D3697

5 08/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/08/2008 2:06:28 PM  
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE RH

Job Number: 41025

Part Number: D36974

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 (FE)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink hole as per dwg D3697

FF 08-08-14

8

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15/08/14 (E)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

D 08-08-22 (E)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22 (E)

Job Completion



MF 08-08-22

**Dart Aerospace Ltd**

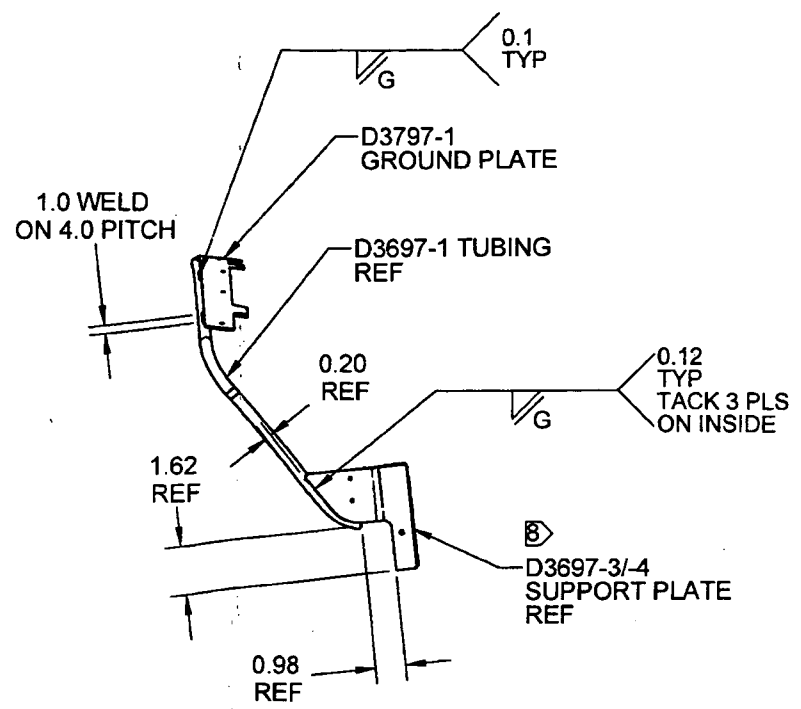
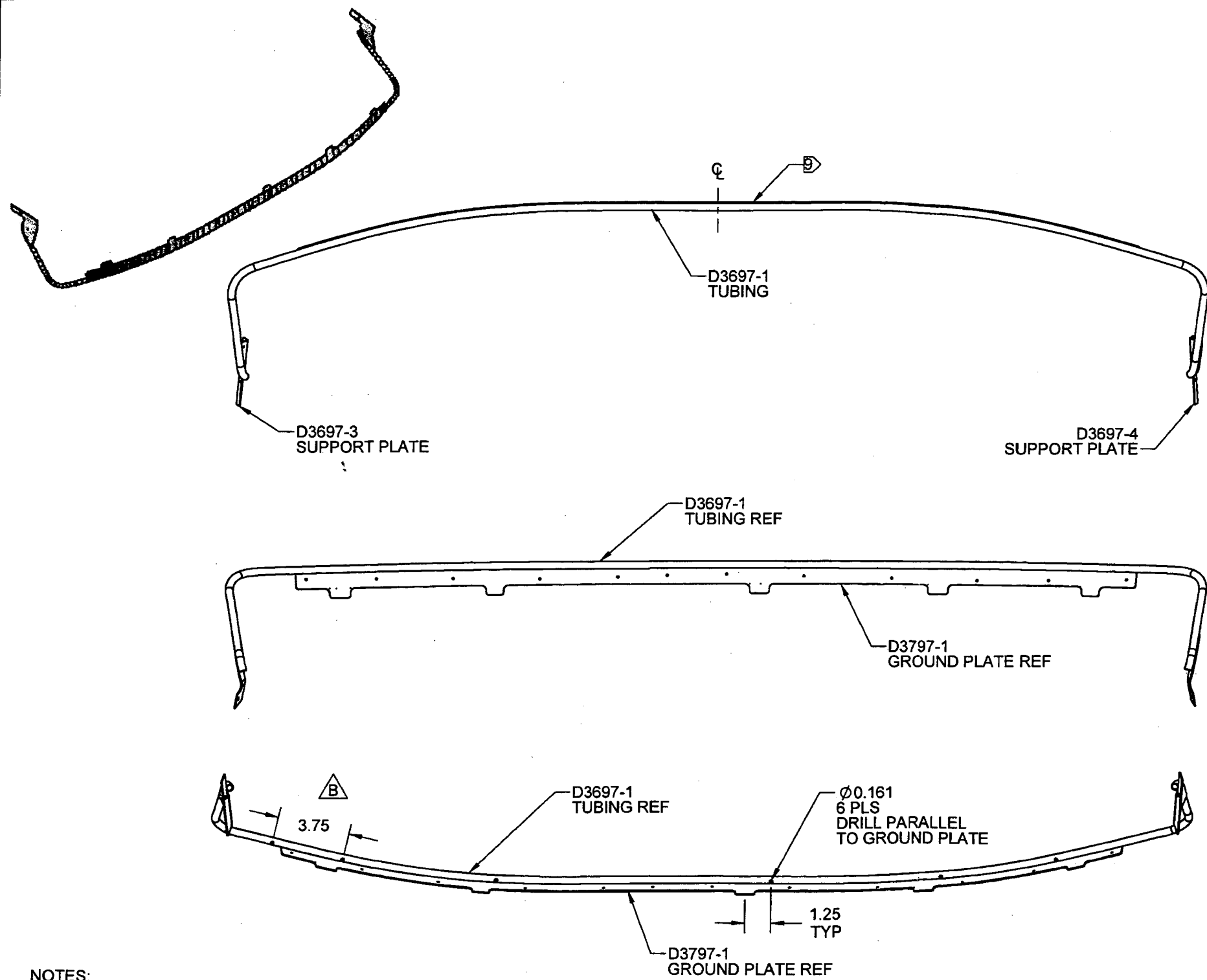
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action 'Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
08-07-08

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

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WORK ORDER  
NO. 44025

- NOTES:
- 1) WELD PER QSI 004
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.55 lbs
  - 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
  - 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

**D3697-041 TUBE ASSEMBLY**

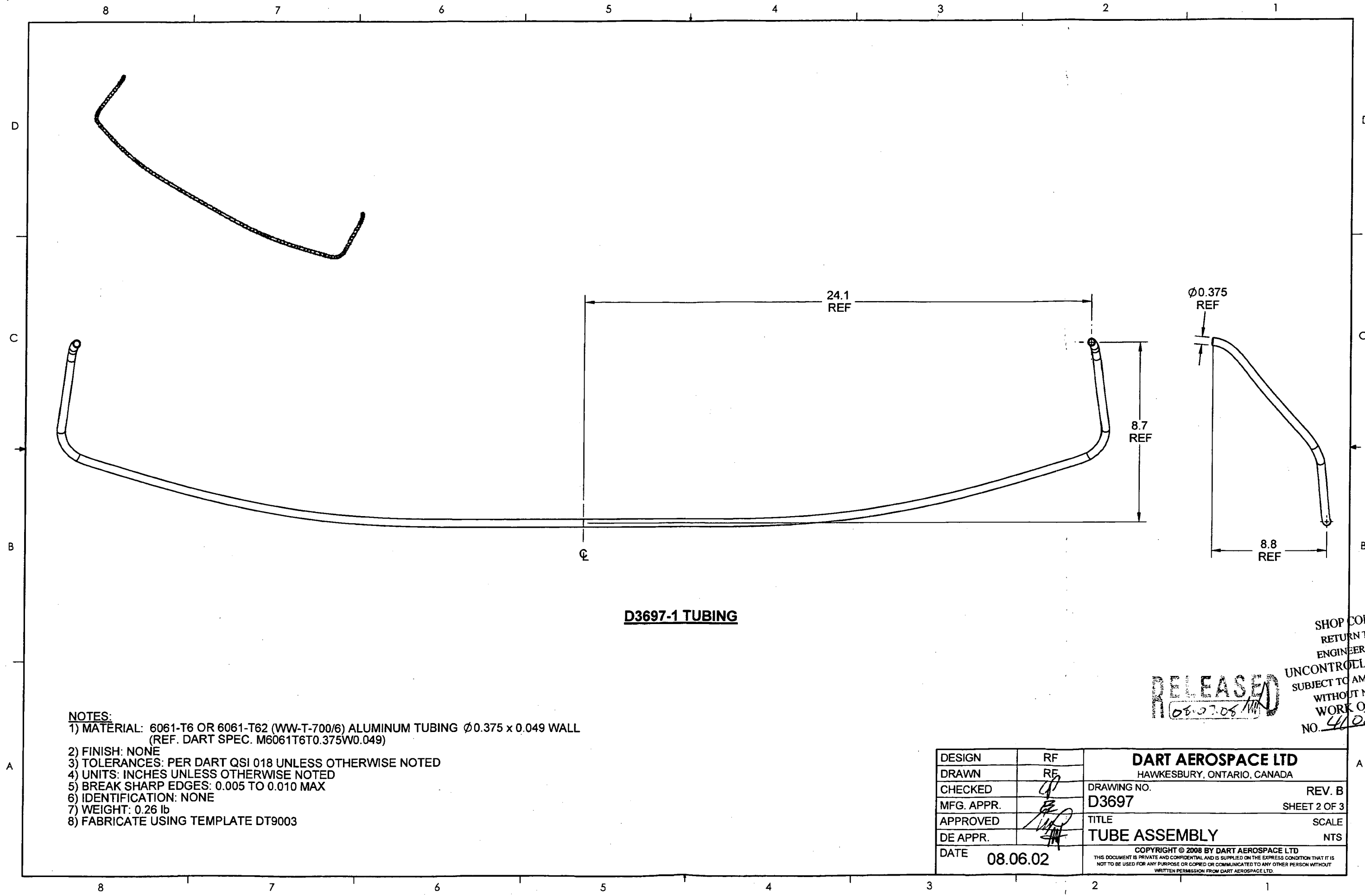
B	REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A,8; ADD Ø0.161 HOLE. SHEET 1 ZONE B,7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.02		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3697** REV. B  
SHEET 1 OF 3

TITLE **TUBE ASSEMBLY** SCALE NTS

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**D3697-1 TUBING**

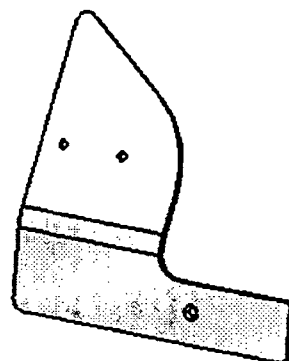
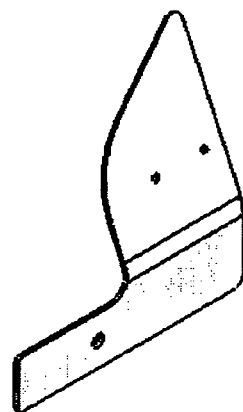
**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 (WW-T-700/6) ALUMINUM TUBING Ø0.375 x 0.049 WALL (REF. DART SPEC. M6061T6T0.375W0.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lb
- 8) FABRICATE USING TEMPLATE DT9003

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08-07-08

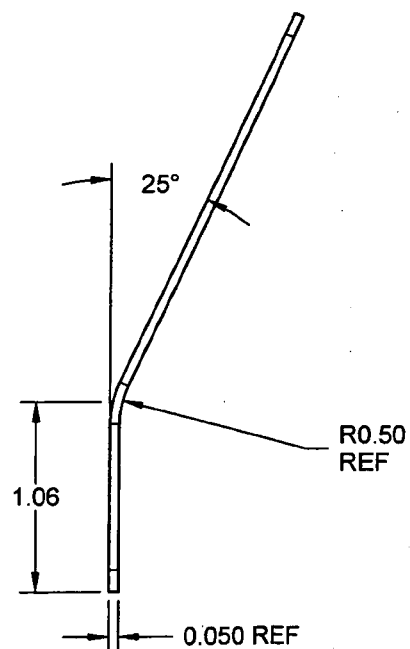
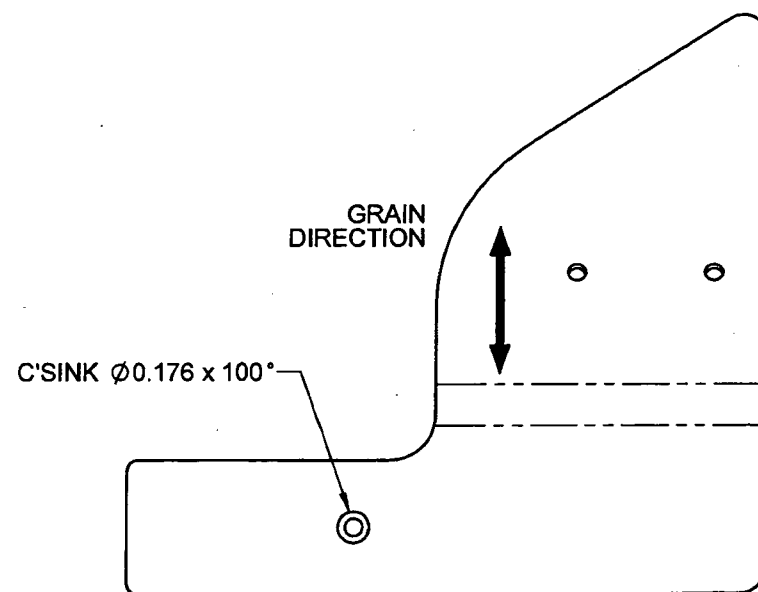
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DATE	<b>08.06.02</b>		

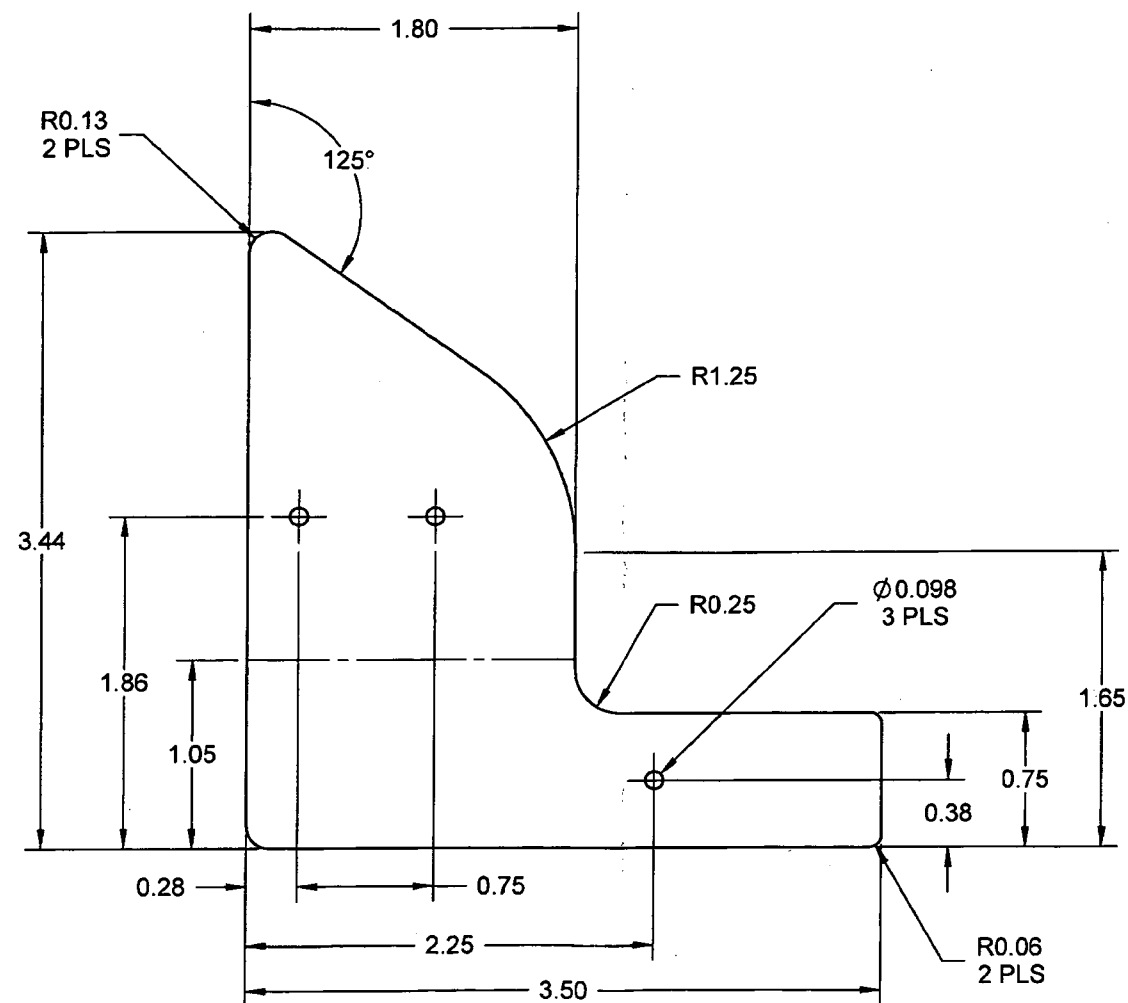


**D3697-3 SUPPORT PLATE (LH SHOWN)**

**D3697-4 SUPPORT PLATE (RH SHOWN)**



**D3697-3 SUPPORT PLATE (LH SHOWN)**  
**(D3697-4 SUPPORT PLATE OPPOSITE)**  
**(MAKE FROM D3697-3F FLAT PATTERN)**



**D3697-3F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

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